

REF ID: A65555

Drawing Name : BRACKET ASSEMBLY

Part Number : D3121141

Drawing Number : D3121 REV D

Project Number : N/A

S.O. No. : N/A

Drawing Revision : D

Type : MACHINED PARTS

Material

Due Date : 9/30/2007

Qty: ~~24~~ Um: Each

n By : 

ed & Approved By : MO 2109.11

ient : Est Rev: Pick: A 04.02.18 New issue KJ/DS

Final Product

umber:



q. #:	Machine Or Operation:	Description :
1	Drilling	Drilling of 10mm dia hole in 10mm thick plate.
2	Turning	Turning of 10mm dia rod to 5mm dia rod.
3	Turning	Turning of 10mm dia rod to 15mm dia rod.
4	Turning	Turning of 10mm dia rod to 20mm dia rod.
5	Turning	Turning of 10mm dia rod to 25mm dia rod.
6	Turning	Turning of 10mm dia rod to 30mm dia rod.
7	Turning	Turning of 10mm dia rod to 35mm dia rod.
8	Turning	Turning of 10mm dia rod to 40mm dia rod.
9	Turning	Turning of 10mm dia rod to 45mm dia rod.
10	Turning	Turning of 10mm dia rod to 50mm dia rod.
11	Turning	Turning of 10mm dia rod to 55mm dia rod.
12	Turning	Turning of 10mm dia rod to 60mm dia rod.
13	Turning	Turning of 10mm dia rod to 65mm dia rod.
14	Turning	Turning of 10mm dia rod to 70mm dia rod.
15	Turning	Turning of 10mm dia rod to 75mm dia rod.
16	Turning	Turning of 10mm dia rod to 80mm dia rod.
17	Turning	Turning of 10mm dia rod to 85mm dia rod.
18	Turning	Turning of 10mm dia rod to 90mm dia rod.
19	Turning	Turning of 10mm dia rod to 95mm dia rod.
20	Turning	Turning of 10mm dia rod to 100mm dia rod.

1.0 M174B1000X02000 17-4 SS Bar



Comment: Qty.: 0.5775 f(s)/Unit Total : 13.8600 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.000x02.000)

Identify for D3121-111

Batch: ~~110114~~ M103089X1870 M114421X6305

5.2 07/10/04

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 6.600" long

3.2 07/11/02

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121Identify as D3121-111

2-Debut.

3-Scribe batch number

31/JF 07/11/03

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3-L / J.F. 07/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

This one is missing from the W/O. It was in Eng, and Qty is 23 with this one.

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/31	3	1 part is scrap because part when out of the fixture.		Scrap replace QTY 13 No replace N/A	J.F. 07/10/31			
07/10/31	3	1 part thickness is .002" under minimum tolerance. A.C. Part moved in the vice when facing.	LE 07.11.13 QS1042	Acceptable. Groove depth measured to be 0.029" and calculation re-done per stress report. Drawing revised to change groove tolerance.	J.F. 07/10/31		LE 07.11.13 QS1042	

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34512

Part Number: D3121141

Number:



q. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JH 07-11-02

6.0 D312121 Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3121-21

Bolt

B 34522

x1

B 34522 x 4 pcs

B 34522

x1

ml 07/11/15

J.L./J.F.

07/11/03

7.0 D3121241 Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3121-241 Bearing Ass

B 34523

B 34523 x1

ml 07/11/15

J.L./J.F.

07/11/03

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3121-141 as per Dwg D3121.ml 07/11/15 (x1)
J.L./J.F. 07/11/03

9.0 QC5 INSPECT WORK TO CURRENT STEP



J.L./J.F. 07/11/03

Comment: INSPECT WORK TO CURRENT STEP

JH 07-11-04 (22)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57.233

JH 07-11-05

07/11/05

J.L./J.F.

07/11/03

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JH 07-11-06

letion:

JH 07-11-05
JH 07-11-20 (1)

DART AEROSPACE LTD		Work Order: 34512
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.393"	✓			
0.75	+/-0.030	0.753"	✓			
0.375	+/-0.010	0.375"	✓			
2.14	+/-0.030	2.142"	✓			
0.950	+/-0.010	0.955"	✓			
0.600	+/-0.010	0.600"	✓			
1.96	+/-0.030	1.968"	✓			
0.280	+/-0.010	0.284"	✓			
3.330	+/-0.010	3.305"	✓			
3.630	+/-0.010	3.634"	✓			
R0.25	+/-0.030	R.250"	✓			
R0.375	+/-0.010	R.375"	✓			
Ø0.201	+0.005/-0.000	0.201"	✓			
0.100	+/-0.010	0.100"	✓			
6.18	+/-0.030	6.170"	✓			
5.89	+/-0.030	5.895"	✓			
0.080	+/-0.010	0.083"	✓			
0.300	+/-0.010	0.300"	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	R.25"	✓			
0.130	+/-0.010	0.125"	✓			
0.381	+/-0.010	0.373"	✓			
0.201	+/-0.010	0.202"	✓			
0.400	+/-0.010	0.398"	✓			
0.580	+/-0.010	0.575"	✓			
100°	+/-0.1°	100°	✓			
0.031	+/-0.010	0.032"	✓			

Measured by: JF
Date: 07/10/31

Audited by: SP
Date: 07/10/31

Prototype Approval: N/A
Date: N/A

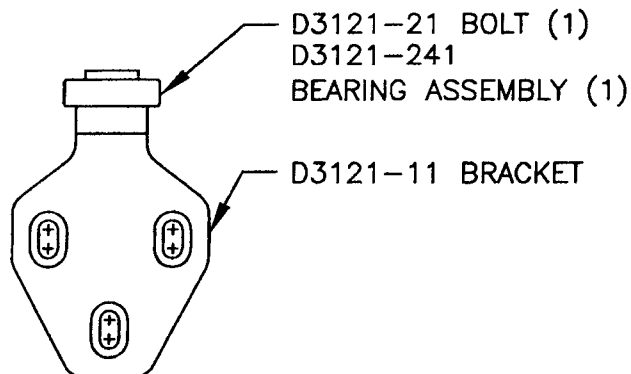
Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	



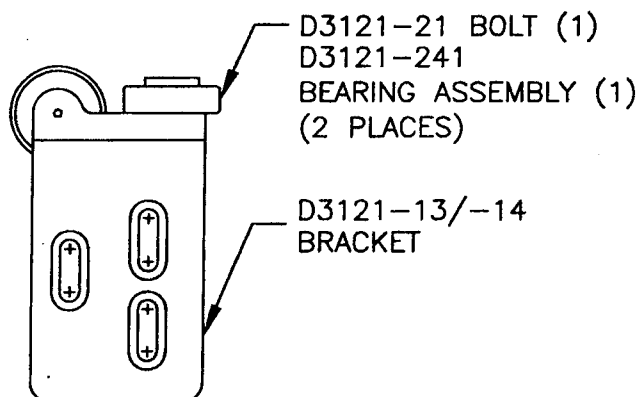
DESIGN	DRAWN BY	DART AEROSPACE LTD	
	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D3121	SHEET 1 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	

RELEASED

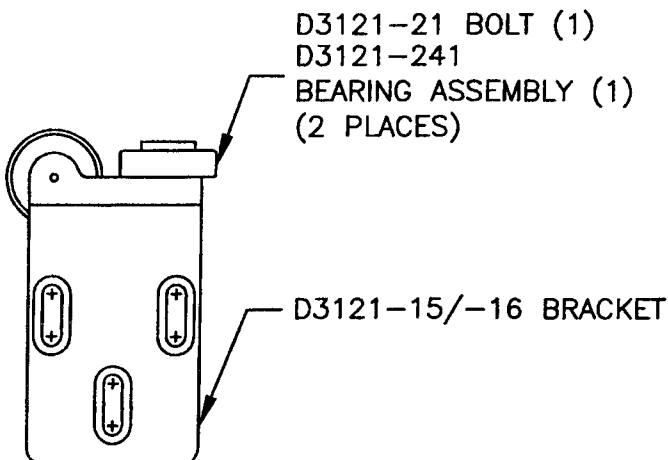
06.06.02



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34512

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.